Al . 625

37	,											
Work Ord Wednesday, Aug												Page 1
Item ID: Revision ID: Item Name:	D3492-1			Accept					Setup	Start Stop		
Start Date: Required Date Reference:	8/31/2011 : 9/9/2011	Start Qty: 100.00 Req'd Qty: 100.00	1884   184   1894     1884   184   1894		Cust Item I Customer:	D:						
Approvals:		n:CZ	Date: _[((08/3/	_		ate:			Run	Start Stop		
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3492	D											
100 . Hardinge		Hardinge CNC LATHE SI	MALL	0.00				118	,	Ø	,	
Hardinge CNC Lath	ne Small	1-Turn as per Dwg Rev: Folio Rev:	Folio FA633 & Dwg D34	0.00 M	119							
110 QC		QC2- Inspect parts off made	chine FAI/FAIB	0.00				//8	<u>د</u> _	9		
Quality Control		Memo	5	\	19							

QC8- Inspect parts - second check

0.00

JL 110919

QC

Quality Control

120

Memo

0.00

W/O:			WC	RK ORDER CHANG	ES		<del></del> .		
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-		
									<b>3</b>
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQA	:	Date: _	
	R	esolution:	Disposition	:	_ QA: N/C CI	osed:		Date: _	<u> </u>
NCR:	:		WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			AP 200
DATE	STEP	Description of NC	Description of NC Corrective			Verifica		Approval	Approval
DAIL	SIEF	Section A	Initial Action Description Chief Eng Chief Eng		Sign 8 Date	Sectio	n C	Chief Eng	QC Inspector
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Page 2

Wednesday, August 31, 2011 3:05:32 PM

Item ID:

D3492-1

Accept

Setup Start

**Revision ID:** 

**Start Date:** 

**Item Name:** 

Required Date: 9/9/2011

Plug

8/31/2011

**Start Qty: 100.00** Req'd Qty: 100.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

**Tooling:** 

Date:

Run

Start

Stop

\_\_\_\_\_ Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

**Work Center ID** 

150

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Number Insp. Stamp

160

Powdercoat

Powder Coating

Quality Control

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

(Flat End Only) START TIME:

**OVEN TEMPERATU** 

FINISH TIME:

QC3- Inspect Part Finish

0.00

Memo

0.00

118×9 m- Lulou/21

	. Johnson								
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	,								
Part No	•	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	\:	Date: _	<u></u>
	Resolution:								
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section		Verific	ation	Chief Eng / Prod Mgr  Date: Date:	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Section			QC Inspector
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					:				

#### Work Order ID 73402

Wednesday, August 31, 2011 3:05:32 PM



Page 3

Item ID:

D3492-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Plug

8/31/2011

Start Qty: 100.00

Req'd Qty: 100.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Required Date: 9/9/2011

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** 

180

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

**Tool ID** 

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Memo

0.00

190

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

M/109-22

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W/O:			WO	RK ORDER CHAN	IGES					
DATE	STEP	PRO	OCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	NCR:	Yes N	lo DQA		_ Date: _	56.41
	Resolution:		Disposition	1:	QA: I	WC Clos	sed:		Date: _	
NCR:		\	WORK ORDE	R NON-CONFORI	MANCE	(NCR)				
DATE	STEP	Description of NC			ection B		Verifica	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Sectio		Chief Eng	QC Inspector
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1	1		1	•	1		1			

### **Picklist Print**

Wednesday, August 31, 2011 3:05:29 PM

Work Order ID: 73402

Parent Item: D3492-1

Parent Item Name: Plug

**Start Date: 8/31/2011** 

Required Date: 9/9/2011

**Start Qty:** 100.00

Required Qty: 100.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			100	f	36.2700	0.0625	6.578947	. 10	19/1	٩

6061-T6 Round Bar .625"

<b>Location</b>	Loc Oty	Loc Code		
MAT012	36.27	*		
117284	26.18			7.7
117481	10.09		,	

Page 1

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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			<u> </u>					·				
Part No	•	PAR #:	Fault Ca	Fault Category: NCR: Yes No DQA:					Date:			
	Re	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date:			
NCR:			WORK OR	DER NON-CONFORM	MANCE	(NCR	)					
DATE	STEP	Description of NC	Corrective Action Section			0:	Verific		Approval	Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Section	n C	Chief Eng	QC Inspector		
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			-									

DART AEROSPACE LTD	Work Order:	73402
Description: Plug	Part Number:	D3492-1
Inspection Dwg: D3492 Rev: D		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.005	.061			21-5	
0.060	+/-0.005	-060				
Ø0.394	+/-0.010	585°				
Ø0.625	+/-0.010	625			-	
0.090	+0.000/-0.002	290	0			
0.500	+/-0.010	~500				
0.050	+0.000/-0.002	.089				
0.050 x 20°	+/-0.010	130X20°				
				1		
				-		

Measured by:	9		Audited by:	- <u>}</u>	Pro	eliminary Approval:	
Date:	U	13/19	Date:	11-09-20		Date:	

Rev	Date	Change	Revised by	Approved
Α	06.06.02	New Issue P/O D3492-041	KJ/JLM	
В	06.10.16	Ø0.625 was Ø0.500	KJ/JLM	
С	07.11.23	Tolerances revised	KJ/EC/DD	
D	08.06.19	0.050 x 20° dimension added	KJ/DD ,	1
E	11.07.26	Dimensions updated per Dwg Rev D	KJ 😽	<b>X</b>

								<del>*************************************</del>
W/O:			WORK ORDER O	HANGES				
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					, "	<u> </u>		
Part No	•	PAR #:	Fault Category:	NCR: Ye	es No <b>DQ</b>	A:	Date: _	
	Resolution	•	Disposition:	QA: N/C	Closed:			-

NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCR)	CR)					
		Description of NC		Corrective Action Section B	Verification	Approval	Annuaral				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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		A Comment of the Comm			1 7 33%						
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D3492-XX PLUG (SEE TABLE) -NAS1611 O-RING (SEE TABLE)

#### **D3492-XXX PLUG PARTS LIST**

QTY -041.	QTY -043	-045	-047	-049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
4-X-							D3492-041	PLUG ASSEMBLY.
	X						D3492-043-	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			Х				D3492-047 ·	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					Х		D3492-051	PLUG ASSEMBLY
						Х	D3492-053	PLUG ASSEMBLY
تراك							D3492-1/	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
<u>-1</u>							NAS1611-010-	O-RING
						1	NAS1611-012	O-RING
	11						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES: 1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO.\_\_73403\_ CL11108/31

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
С	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
Α	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN		_ DAKIALKU	DAPACE LID			
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA				
CHECKED	_4	DRAWING NO.	REV. D			
MFG. APPR.	JER	D3492	SHEET 1 OF 2			
APPROVED	VAK	TITLE	SCALE			
DE APPR.	7	PLUG	2:1			
DATE 11.0	05.24		DART AEROSPACE LTD IS SUPPLIED ON THE SUPPLIES CONDITION THAT IT IS COMMUNICATED TO ANY OTHER PERSON WITHOUT			

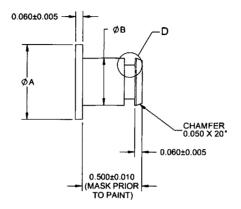
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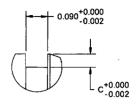
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W/O:		W	ORK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
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DATE	OTED	Description of NC	Description of NC Corrective A		tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	tion C	Approval Chief Eng	QC Inspector
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-POWDER COAT THESE FACES ONLY PER NOTE 2





DETAIL D

D3492-XX PLUG

#### **D3492-XX PLUG MACHINING DETAILS**

P/N	Α	В	C	MATERIAL SPEC	_
D3492 1	0.625	0.394	0.050	M6061T6R0.625	=
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	-/6

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061 T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

7

D

DESIGN DRAWN	PH AJS		DSPACE LTD INTARIO, CANADA
CHECKED	1 15	DRAWING NO.	REV. D
MFG. APPR.	JESA	D3492	SHEET 2 OF 2
APPROVED .		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE 11.0	05.24		

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8

2

W/O:		MANAGE TO THE TOTAL PROPERTY OF THE TOTAL PR	WO	RK ORDER CHAN	GES								
DATE	STEP	PROCEDURE CHANGE			By Date Qty				Approval QC Inspector				
Part No	:	PAR #:	Fault Categ	jory:	NCR: Ye	es No DO	PA:	Date: _					
Resolution:		Disposition: C			Closed: _	osed: Date:							
NCR:				R NON-CONFORM	IANCE (N	CR)							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Security Action Description  Chief Eng	ction B Sig		ication tion C	Approval Chief Eng	Approval QC Inspector				
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